

Date: Thursday, 15/01/2009 2:01:56 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STOPPER
 Job Number : 44854
 Estimate Number : 13246
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 38721
 Written By : 09.01.15
 Checked & Approved By :
 Comment : Est Rev:A 08-03-27 new issue DD verified by:JLM

Part Number : D36953
 Drawing Number : D3695 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material :
 Due Date : 22/01/2009 Qty: 3 Um: Each

Additional Product

Job Number:



09.01.15 per ECU#09-5028
PRELIMINARY ISSUE



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X03500 6061-T6 Bar 2.50 x 3.50



Comment: Qty.: 0.3728 f(s)/Unit Total: 1.1183 f(s)

6061-T6 Bar 2.5" x 3.5"

BATCH: M102838

J.F. 09/01/16

2.0 BAND SAW BAND SAW



Comment: Cut blank 4.25" long

J.F. 09/01/16

(3)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA733 Rev: AA & Dwg D3695 Rev: C

2-Deburr per dwg D3695

3-TAP FOR 3/8"-16 HELICOIL

J.F. 09/01/16

(3)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/16

(3)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

(3) 09.01.19

**ENGINEERING
APPROVAL**

09/01/19

(3)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOPPER

Job Number: 44854

Part Number: D36953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

G.m 09.01.19 (3)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

*****MASK ALL HOLES AS PER DWG D3695*****

START TIME:

3:45

OVEN TEMPERATURE:

320°

FINISH TIME:

4:15

FL 09/01/19

(3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

G.m

09.01.20 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

ST 118 MF 09-02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23 (J)

Job Completion



POSITIVE RECALL

EFFECTIVE

09.01.19 AUTH

RELEASED

DATE 09.02.19

MF 09-01-20

DART AEROSPACE LTD		Work Order: 44854
Description: Slider Assembly		Part Number: 03695-3
Inspection Dwg: 03695 Rev: C		Page 1 of 1

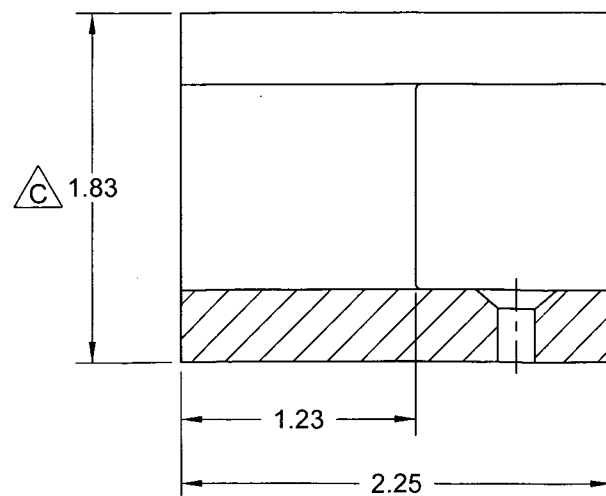
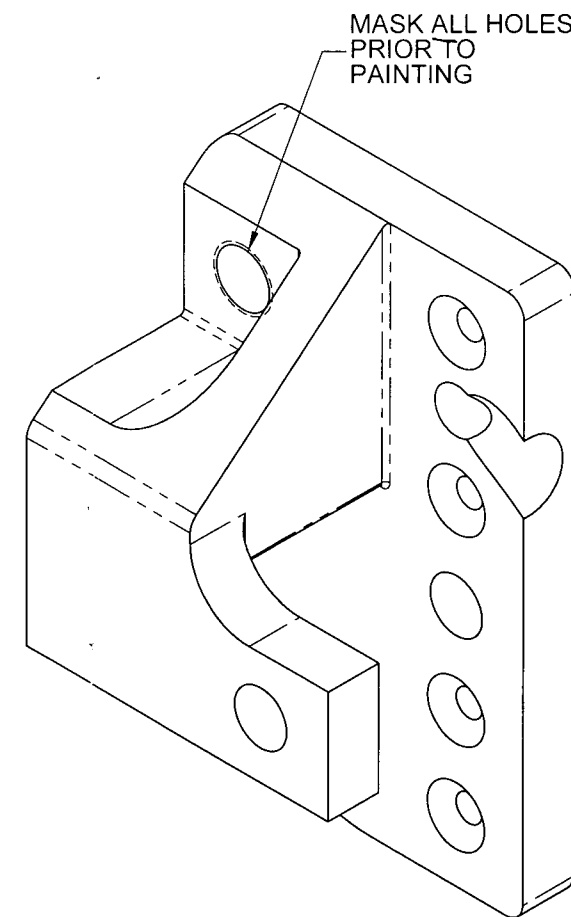
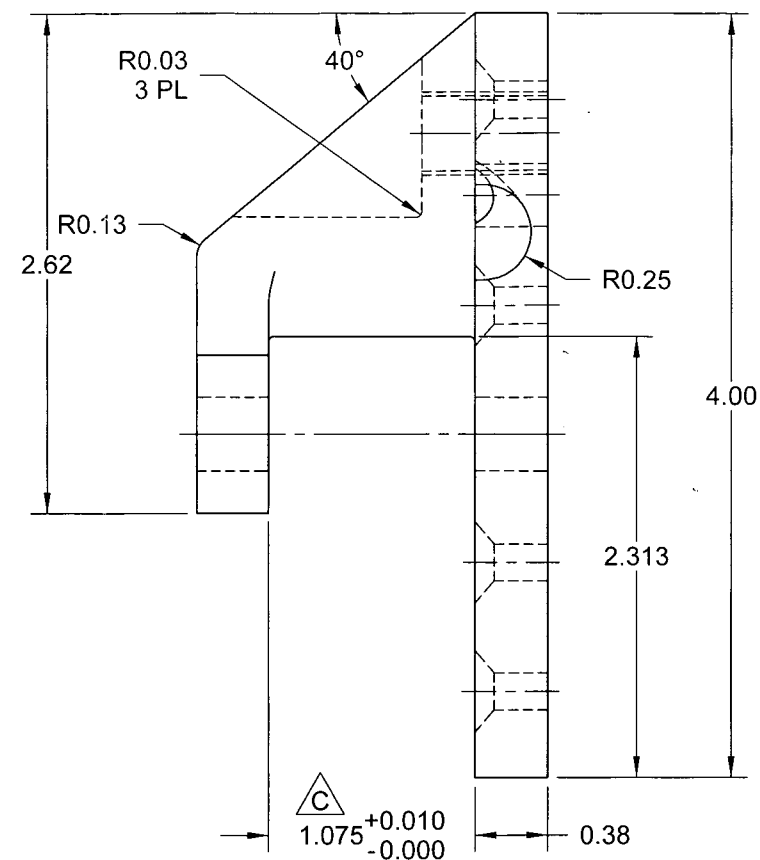
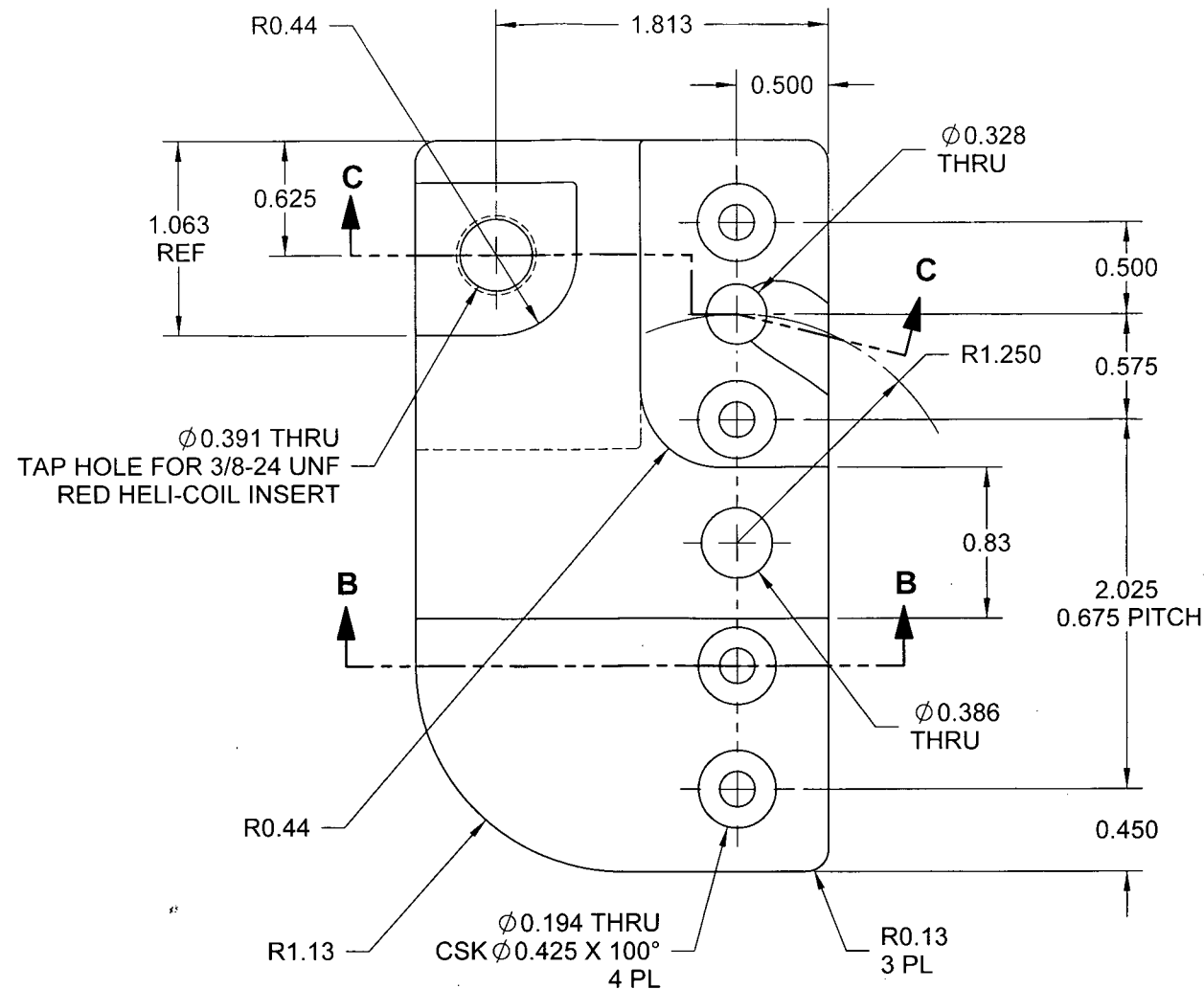
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

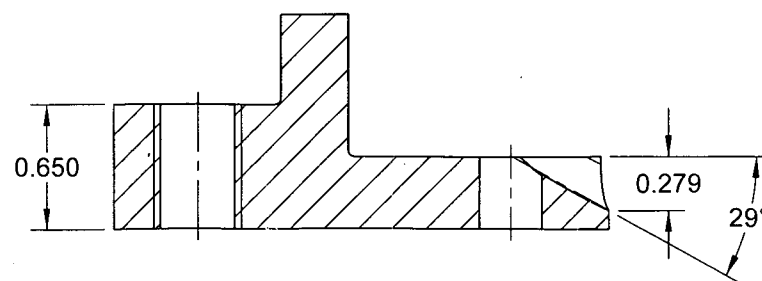
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.813"	±.010"	1.808"	✓			
.500"	±.010"	.495"	✓			
Ø.328"	±.006 -.001	Ø.331"	✓			
.500"	±.010"	.501"	✓			
.575"	±.010"	.575"	✓			
.83"	±.030"	.825"	✓			
Ø.386"	±.006 -.001	Ø.390"	✓			
2.025"	±.010"	2.025"	✓			
.450"	±.010"	.450"	✓			
R.0.13"	±.030"	R.13"	✓			3PL
Ø.194"	±.005 -.001	Ø.194"	✓			4PL
Ø.425 x 100°	±.010"	Ø.422"	✓			4PL
R.1.13"	±.030"	R.1.13"	✓			
R.44"	±.030"	R.44"	✓			
Ø.391"	±.006 -.001	Ø.394"	✓			
* 1.063"	±.010"	1.058"	✓			
.625"	±.010"	.625"	✓			
1.83"	±.030"	1.815"	✓			
1.23"	±.030"	1.224"	✓			
2.25"	±.030"	2.250"	✓			
- .650"	±.010"	.650"	✓			
- .279"	±.010"	.269"	✓			
* 2.62"	±.030"	2.608"	✓			

Measured by: J.F.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/01/16	Date: 09/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SECTION B-B



SECTION C-C

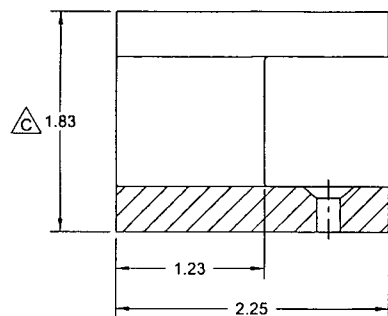
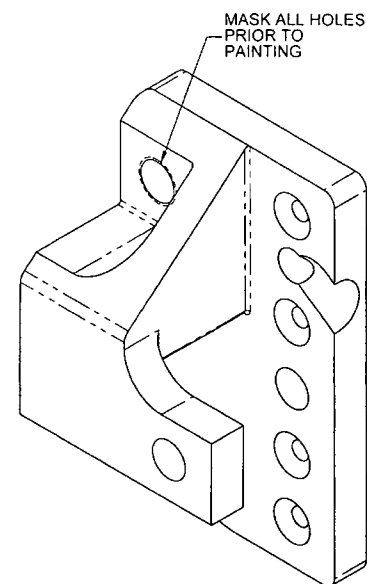
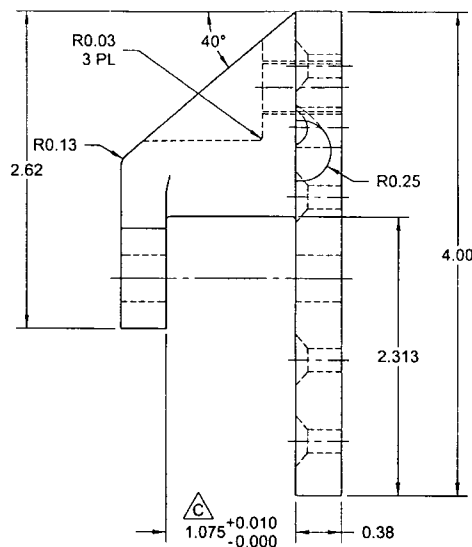
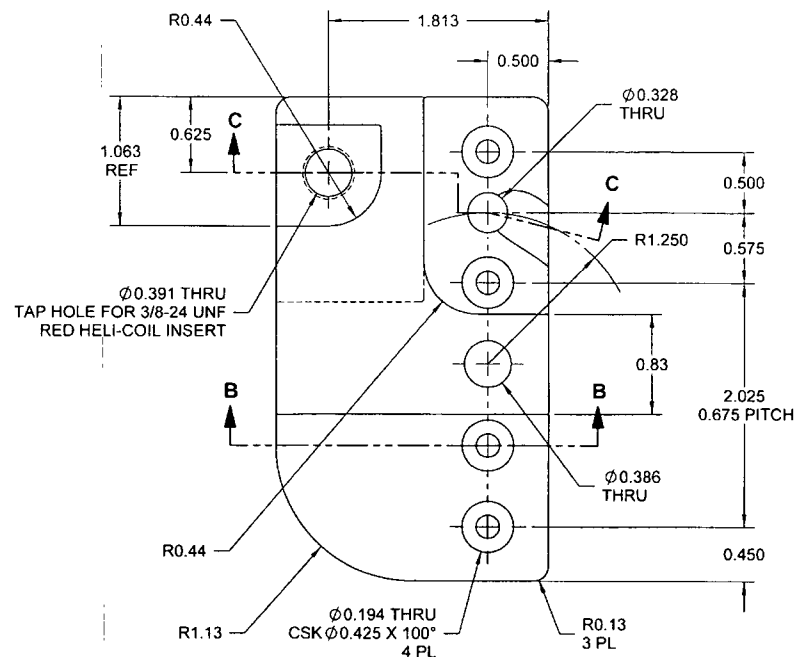
D3695-3 STOPPER

PRELIMINARY ISSUE

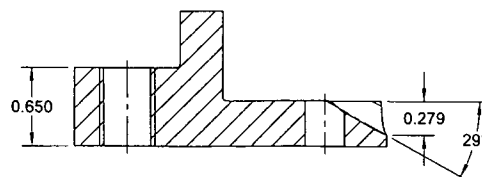
D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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SECTION B-B



SECTION C-C

D3695-3 STOPPER

RELEASED
9/2/05 NMP

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
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(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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